

Work Order ID 121297

June-20-14 2:31:07 PM

121297

Page 1

Item ID: D4868-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 206L Leg Assembly
 Start Date: 6/20/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 6/20/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: N Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4868	B								

110

0.00

110

Small Fab

Small Fab

Memo

PULL FROM STK:
 2 X D4868-041 B 116534
 SWITCH HILOCS TO OTHER SIDE TO MAKE -042

0.00

2

0

0

AP

4-6-20

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Quality Control

Memo

0.00

5/14/20

Pho →

Last Page

130

0.00

130

Small Fab

Small Fab

Memo

INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL
 WET AS PER DWG USE DT9965
 A/R HYSOL BATCH: _____

0.00

AP/A

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo <i>NA u</i>	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <i>ppp 121265</i>	0.00							
150									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

u 14-06-23

MLD 14-06-23

W 14-06-23

Picklist Print

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Work Order ID: 121297

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Parent Item: D4868-042

D4868-042

Parent Item Name: 206L Leg Assembly

Start Date: 6/20/14

Required Date: 6/20/14

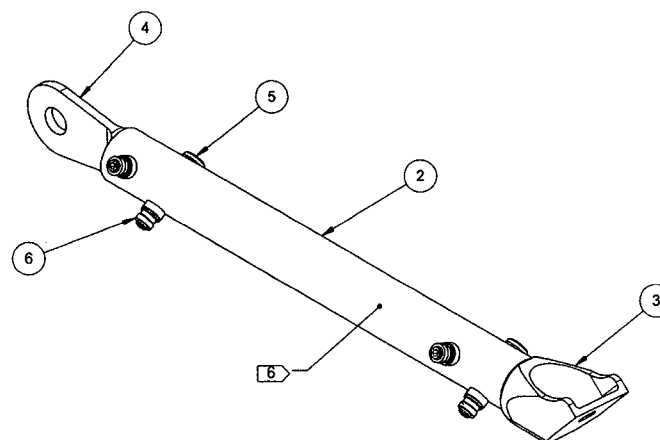
Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.06.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4868-041		Manufactured	No				Each	4.0000		2			
D4868-041									**			As 14-6-20	
206L Leg Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST123		4							
				116534		4				8			
HL20PB5-12		Purchased	No				Each	188.0000					
HI 20PB5-12									**			As 14-6-20	
Rivet													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST265		188							
				M128110		38							
				M128973		150				8			
HL86-5		Purchased	No				Each	249.0000					
HI 86-5									**			As 14-6-20	
Collar													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST263		249							
				M128110		12							
				M128228		37							
				M129022		200							

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4868-042	LEG ASSEMBLY
2	1	D4868-1	STRUT
3	1	D4871-1	END FITTING
4	1	D4871-3	END FITTING, EYE
5	4	HL20PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4868-042 LEG ASSEMBLY
(EQUIVALENT TO BELL P/N 206-063-107-005)

NOTES:

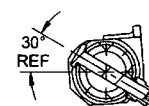
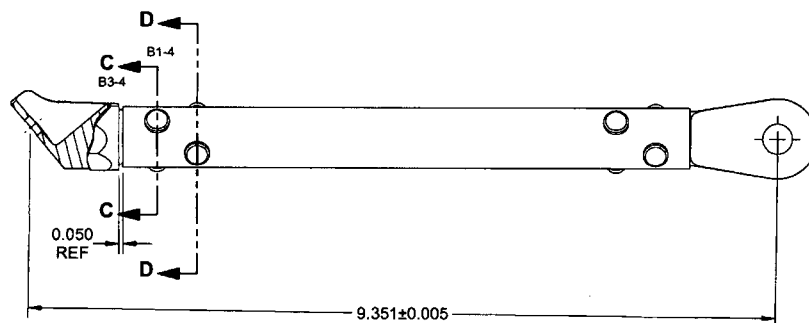
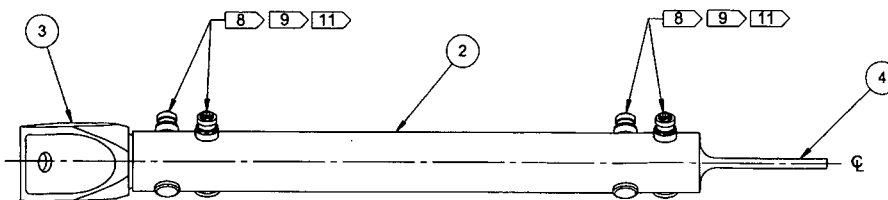
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.59 lbs
- 8) ALIGN PILOT HOLES IN D4868-1 WITH PILOT HOLES IN D4871-1 & D4871-3.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9965
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9965
- 11) INSTALL HL20PB5-12 HI-LOK IN ORIENTATION SHOWN

APPROVED

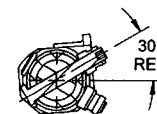
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4868	REV. B
MFG. APPR.	JLM		SHEET 3 OF 5
APPROVED	HS	TITLE LEG ASSEMBLY	SCALE NTS
DE APPR.	DS		
DATE	14.04.08	<small> COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

RELEASED
2014-06-16

121297



SECTION C-C C7-4
2 PL



SECTION D-D C7-4
2 PL

D4868-042 LEG ASSEMBLY
AUXILIARY VIEW

RELEASED
2014-06-16

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA.	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4868	REV. B
MFG. APPR.	JLM		SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>121297</u> Part No. <u>D4868-042</u> NCR No. _____	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td style="width:33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width:33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width:33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input checked="" type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> </tr> <tr> <td colspan="3" style="text-align: right;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input checked="" type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		
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Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>								

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		14/06/20	12	42	PART MARK AS-ASSY D4868-042 PARTS WERE NOT LASER MARKED INCORRECTLY. RC.		Re send Back to MARK correctly.			
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		